

Date: Tuesday, 28/10/2008 3:26:29 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CUPPED WASHER
<b>Job Number</b> : 43031	
<b>Estimate Number</b> : 12908	
<b>P.O. Number</b> :	<b>Part Number</b> : D36283
<b>This Issue</b> : 28/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3628 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 32924	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 14/11/2008 <b>Qty:</b> 500 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>NO 08.10.28</u>	
<b>Comment</b> : Est Rev:A New Issue 07-05-28 JLM Est Rev:B Removed Powder Coat 07-07-11 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** Issue P/O: 7475  
 Email or Ship DXF file to vendor  
 Laser Cut D3628-1 flat pattern and form as per Dwg D3628  
 Possible Supplier: GFI  
 Material release note is required

C 208 1101 28

500

2.0	D36283	Cupped Washer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 500.0000 Each(s)  
 CUPPED WASHER

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

P 08/11/26 ow

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

S 08/11/28 counter 500

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock  
 Location: 114

S 12/11

500 SQ

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 28/10/2008 3:26:29 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 43031

Part Number: D36283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/02 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-02

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

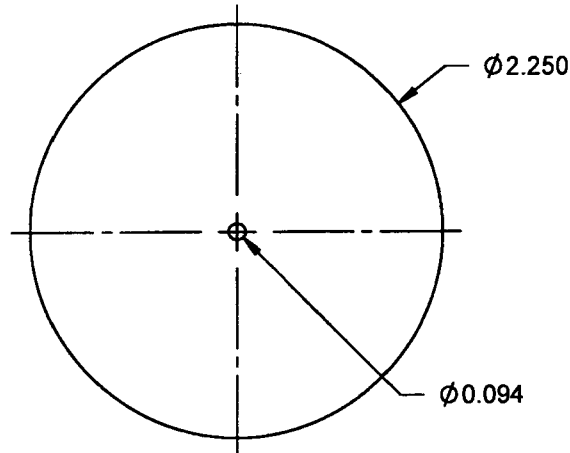
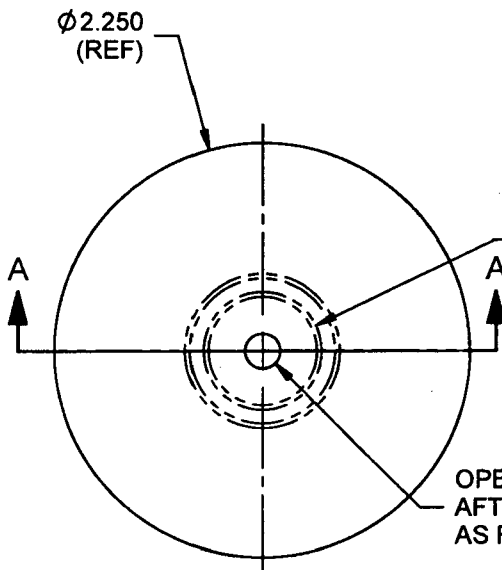
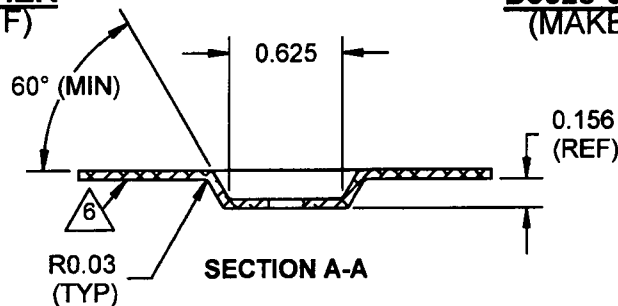
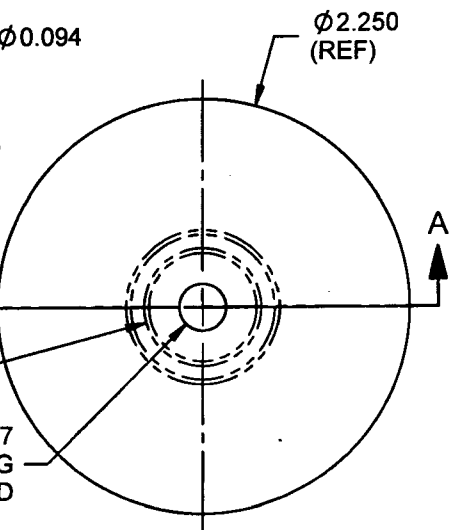
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3628</b>	REV. B SHEET 1 OF 1
DATE <b>07.07.09</b>		TITLE <b>CUPPED WASHER</b>	SCALE 1:1
REV	DATE	DESCRIPTION	
A	07.06.08	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

**RELEASED**07.07.09 **[Signature]****D3628-1F FLAT PATTERN****D3628-1 CUPPED WASHER**  
(MAKE FROM D3628-1F)PUNCH  $\varnothing 0.64 \times 0.16$  DEEPPUNCH  $\varnothing 0.64 \times 0.16$  DEEPOPEN TO  $\varnothing 0.191$   
AFTER PUNCHING  
AS REQUIREDOPEN TO  $\varnothing 0.257$   
AFTER PUNCHING  
AS REQUIRED**SECTION A-A****D3628-3 CUPPED WASHER**  
(MAKE FROM D3628-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43031

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180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CAN. JA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

ENVOYÉ / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7



# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/11/25	0408912

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° CONTRAT DB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J013025	PO00007475	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
500	D36283	CUPPED WASHER  CERTIFICATE OF CONFORMANCE REQ		

*8036129*

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1: 70 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

*Schulz*

CERTIFICATE NO. <b>2</b>		OUR JOB NO. <b>J0193025</b>		SHIPPING MEMO <b>0408912</b>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<b>500 PCS</b>	<b>PO00007475</b>	<b>D36233</b>	<b>B</b>	<b>CUPPED WASHER</b>	<b>B</b>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<b>AMS 5513 304 ANN</b>		<b>TW METAL / ALLEGHENY LUDLUM</b>		<b>H/N # 947041</b>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCES ABOVE.

DATE **25 NOVEMBER 2008**

G.F.I. Q.C. REP.

*Calton North*

DP12-001 REV 0 Bombardier Certificate of Compliance  
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: CSTI, Inc.  
PURCHASE ORDER No. 0274610  
ITEM No. 0001 SHIPPER INVOICE No. 03241965  
MATERIAL SLS Sheet SPECIFICATION: Ams 5513  
MANUFACTURING MILL: Hlegary  
SIZE: 1050 HEAT / LOT No. 947041  
PART No. TS05048X9641 QUANTITY: 2 pcs  
TEST DEPARTMENT CLERK Janice Clark

AUTHORITY

Joe Schab  
Director of Quality Assurance

S  
08/11/24

This document is maintained as a Controlled Document only in the TW Metals computer system. Once printed, this document immediately becomes Uncontrolled and is subject to change at any time and without notice.

449199582

NOTICE OF SHIPMENT/  
PACKING LIST



CERTIFICATE OF TEST

AL 6168-3 407

CUST. ORD. NO. & DATE 01012647		CUST. CODE 104/30/08	110977	ACCEPTING MILL NEW CASTLE, IN.	SHIPPER NO. S90040	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 130-058-618	DATE SHIPPED 06/19/08
SOLD TO 1	FORMS DISTRIBUTION SHIP TO 1	1	1	82037-5	26	1124	NEW CASTLE	IN
SOLD TO		PRIME SEC.		SHIP TO		076383		
		DSO DSO						
		584						

S  
05/10/09

GRADE AND SPECIFICATIONS

CARRIER - KAPLAN TRUCKING

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LC REQUIREMENTS)

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001B	1	48./0.50/2122.	947041	05228N786	7743524	17210	65	17145		169998		
		P CUST IDENTITY 00624										
		1 SKID				17210	65	17145				

TYPE HEAT/TEST	--C--	--MN--	--P--	--S--	--SI--	--CR--	--NI--	--MO--	--CU--	--N--
HEAT 947041	.018	1.44	.032	.0005	.34	18.08	8.07	.33	.46	.04
CHECK 7743524	.018	1.46	.031	.001	.35	18.14	8.03	.32	.45	.04

ITEM TEST NO	PSI *	PSI	IN 2"	% R/A	HARDNESS	BEND	A 262 PR E	SIZE
001B 7743524	T 41900.	96500.	64.		84.HRBW	T PASS	PASS	9.
	* Y.S. BY 0.2% OFFSET METHOD							

ITEM TEST NO	MELT	P&W E-25
001B 7743524	SOURCE	TRAN BEND
	1.	2.

METALLOGRAPHIC MAGNIFICATION: 100X ETCHANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

06/19/08 14:09:31

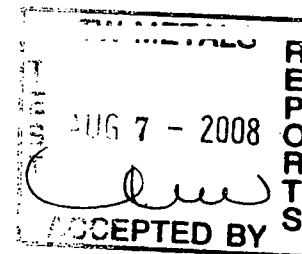
CONSIGNEE'S Please Note - This consignment has been turned over to carrier in its clean condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceases. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, note a full description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6577. Attention: Les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

One M. Xorals - Director, Corporate Quality Assurance



REVIEWED BY Q.C.

Date 6/23/08 By [Signature]

U49199582

NOTICE OF SHIPMENT/  
PACKING LIST



CERTIFICATE OF TEST

AL 6168-3 407

CUST. ORD. NO. & DATE 01012647		CUST. CODE 104/30/08	110977	ACCEPTING MTL NEW CASTLE, IN.	SHIPPER NO. 590040	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-058-618	DATE SHIPPED 06/19/08
FORMS DISTRIBUTION SOLD TO 1		REPEAT ORDER 82037-5		DO RATE 126	GOVT CONTRACT	MATL 1124 NEW CASTLE	SHIPPING LOCATION IN	INVOICE 076383
SOLD TO		PRIME DSO 584		SEC. DSO		SHIP TO		

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA B/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LCS REQUIREMENTS)

CARRIER - KAPLAN TRUCKING

AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUMS KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

THE FOLLOWING CONDITIONS UNDER WHICH SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014
2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES

TW METALS

AUG 7 - 2008

*[Signature]*

ACCEPTED BY

REPORTS

PAGE 02 - CONTINUED ON PAGE 03

06/19/08 14:09:31

CONSIGNEE: Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing this makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires, veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegany Ludlum's Order Acknowledgement.

Don M. Xenakis  
Director, Corporate Quality Assurance

M49199582

NOTICE OF SHIPMENT/  
PACKING LIST

## CERTIFICATE OF TEST

AL 6168-3 407

CUST. ORD. NO. & DATE 01012647	CUST. CODE 04/30/08	110977	NEW CASTLE, IN.	SHIPPER NO. 590040	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-058-618	DATE SHIPPED 06/19/08
FORMS DISTRIBUTION SOLD TO → 1	REPEAT ORDER 82037-5	DO RATE 26	GOVT CONTRACT	MATL 1124	SHIPPING LOCATION NEW CASTLE	INVOICE IN	076383
SPEC	PRIME SEC.	DSO DSO		SHIP TO			
	584						

## GRADE AND SPECIFICATIONS

## CARRIER - KAPLAN TRUCKING

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THIS CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ALC QUALITY MANUAL REVISION 17 DATED 05/12/2008. ALC HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001. DIN EN 10204:2005 - 3.1. ALLEGHENY LUDLUM IS APPROVED AS A MANUFACTURER ACCORDING TO AD-MERK BLATT WO/TRD100 AND THE PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC. TESTING WAS PERFORMED AT ALC NADCAP AND ISO/IEC 17025 APPROVED LABORATORIES LOCATED AT NATRONA HEIGHTS, BRACKENRIDGE, LATROBE, MIDLAND, PA AND NEW BEDFORD, MA FACILITIES OR A NADCAP AND ISO/IEC ACCREDITED LABORATORY.

ALLEGHENY LUDLUM WORKS TO THE ROLLS ROYCE RR9000 SABRE REQUIREMENTS.

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:

C, S BY COMBUSTION/INFRARED

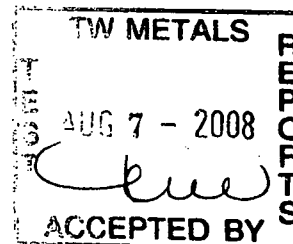
N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY

MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF

B BY OES

AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES

PB, BI, AG BY GFAA



Moor #

Cust PO #

Pt #

Alloy/Spec

Quantity &amp; Size

Mill

Lot #

Authorized Signature

Moor Metals Inc.

M-13610

M49199582

51073

304 AMS 55B

1386 # .050 X 36.00 X 120.00

Allegheny Ludlum

947041

J. Jurek

NY LUDLUM - 6/20/2008 08:27

/ CORPORATE QA DEPT.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

à ce produit ont été fournies à votre tour obtenir des exemplaires supplémentaires à l'attention 724-228-6577. Attention: les données de valeurs, positions, ou solutions fournies. Pour plus de renseignements se

Dee M. Karalis  
Director, Corporate Quality Assurance